

Date: Tuesday, 21/10/2008 2:47:07 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	350 SKIDTUBE ASSEMBLY RH
<b>Job Number</b> :	42781		
<b>Estimate Number</b> :	10265		
<b>P.O. Number</b> :		<b>Part Number</b> :	D350636012
<b>This Issue</b> :	21/10/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2750 REV F
<b>First Issue</b> :	1 / 1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	42557	<b>Drawing Revision</b> :	F
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JLD 08.10.21	<b>Due Date</b> :	10/11/2008
<b>Comment</b> :	Est Rev:I 02.09.25 Rearranged procedure steps KJ Est Rev:J 06-03-29 As per Rev D EC Est Rev:K 06-07-13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4,13 DD verified by:EC Est Rev:N 08-09-23 revF as per dwg DD verified by:ec		
<b>Qty:</b>	1	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JLD 08.11.05



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

SOS/ulor

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

42342 5L8-10-26

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch

239242 BC 8-10-27

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 &amp; DT8863.

5L8-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

3- Mark fwd-end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8383. Open to 0.500"

5- locate DT8923 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m109213 BE 08/12/27*

10-Grind welds flush as per Dwg D2750

11- scribe batch #.

*SL 8-10-26*

*AWM 8-10-28*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*8 08/10/28 (X)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8 08/10/28 (X)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*D 14 8-10-28*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DP 8-10-28*

W/O:		WORK ORDER CHANGES					
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Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

B-42922

AWM 8-10-27

10.0	D34901	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B42780

RF 8-10-29

11.0	D34903	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B42186

RF 8-10-29

12.0	D2743	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

B41113

RF 8-10-29

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

H  
7-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R

Sikaflex-291

batch: M107447  
exp. date: 8-11-00

Ann 8-10-27

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 9)

A/R

Aluminum Rod

batch: M109213 BE 8-11-29

9-Grind welds flush as per Dwg D2750 JB 8-10-29

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 JP 8-10-30

11-Debur holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/30 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-L 08/11/03

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40  
320 OF  
4:10

M-L 08/11/03

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

MS 08-11-05 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032225	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M100621

JS

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

JS

08-11-05

(X1)

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B40726

JS

22.0	D37911	Wearplate
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B42418

JS

23.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B42479

JS

24.0	D37933	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B42247

JS

25.0	D37941	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B42480

JS

08-04-05

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D37943	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B43116

*JW*

27.0	D353525	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B41633

*JW*

28.0	D353625	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B42234

*JW*

29.0	D35371	Wearpad
------	--------	---------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

WEARPAD

Batch: B42235

*JW*

30.0	D36311	Washer
------	--------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B41141

*JW*

31.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, RH

Batch: B42415

*JW*

08-11-05 (XV)

32.0	NAS1611010	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

NAS1611-010 batch: \_\_\_\_\_

(or MS28775-010) batch: \_\_\_\_\_

*N/A*

*u*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
O-RING  
batch: \_\_\_\_\_

*N/A*  
*u*

34.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: *1342637*

*JS*

35.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: *1342183*

*JS*

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)  
Bolt  
Batch: *M1109752*

*JS*

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
Batch: *M1108880*

*JS*

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT  
Batch: *M1109765*

*JS*

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOLT  
Batch: *M1106896*

*JS*

08-11-05

*JS*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M109545

*JD*

41.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M109632

*JD*

42.0	MS210436	NUT
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M109249

*JD*

43.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M109545

*JD*

44.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M108964

*JD*

45.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

✓ batch: M107912

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

✓ BATCH: M109449

EXP DATE: 08/11

*JD* 08-11-05 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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4-assemble o'ring as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: N/A CL 08/11/05

5-Coat all exposed fasteners with "LPS Procyon"  
batch: 1104251

SS 08-11-05 (X)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/11/05 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 46724

SS 08/11/05 (X)

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M169632

SS 08/11/05 (X)

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M109740

SS 08/11/05 (X)

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109772

SS 08/11/05 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42781

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

52.0 NAS1515H8L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

JS 08/11/05 (X)

53.0 D34931 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 40829

JS 08/11/05 (X)

54.0 D35321 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: 42350

JS 08/11/05 (X)

55.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/11/05 (X)

56.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev G

8/11/5

(X)

SP

57.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/05 (X)

Job Completion



MF 08-11-05

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

NO. 177

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barchy Elliot  
Job number: 142449  
Part number: 1350-636-013  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Smith Date of Test Coupon 08/10/20

Welder Barchy Elliot Date of Test Coupon 08/10/20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

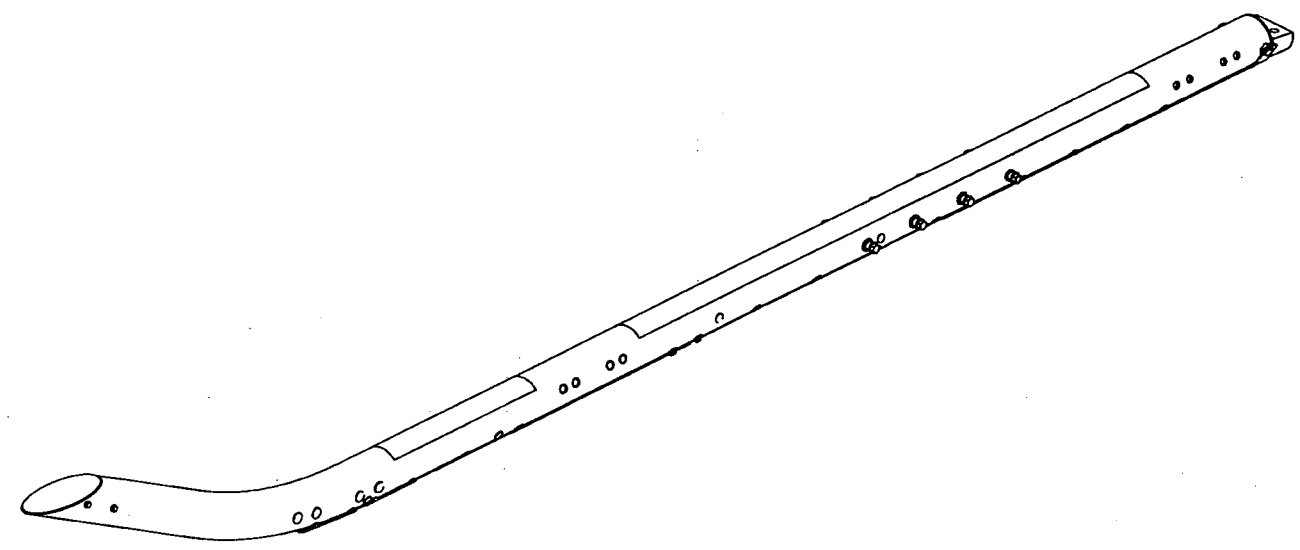
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

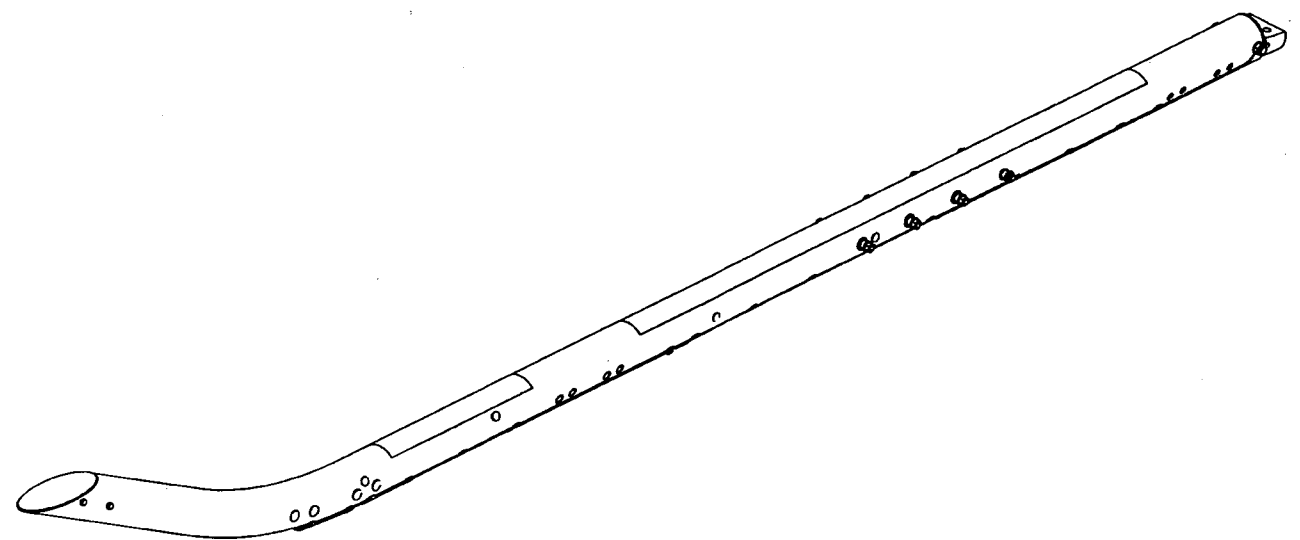
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 1 OF 11
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DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
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**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

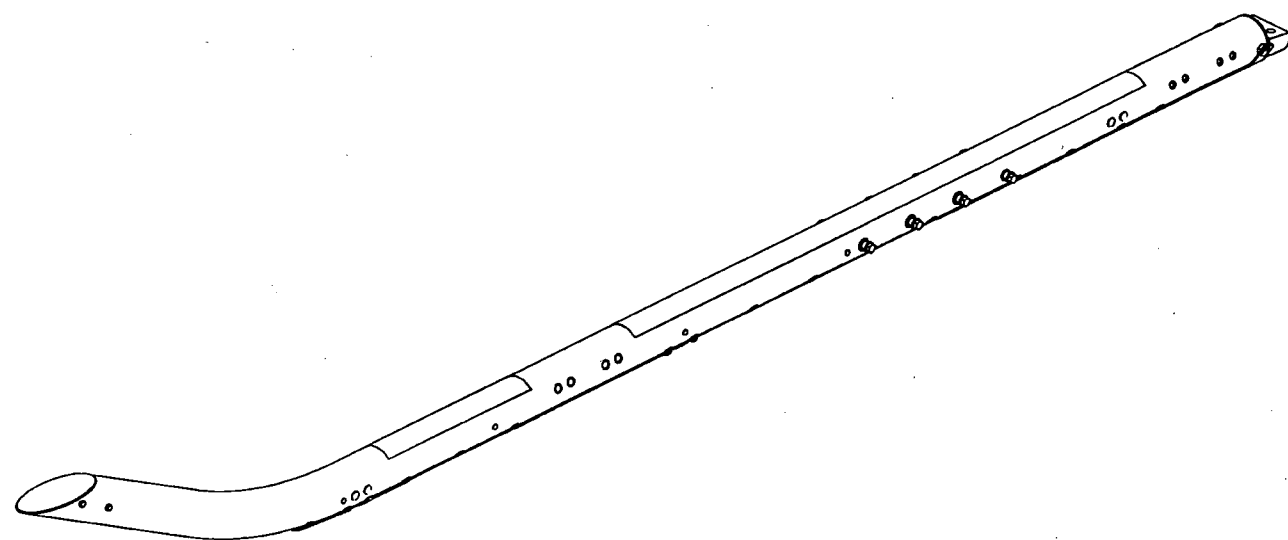


**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

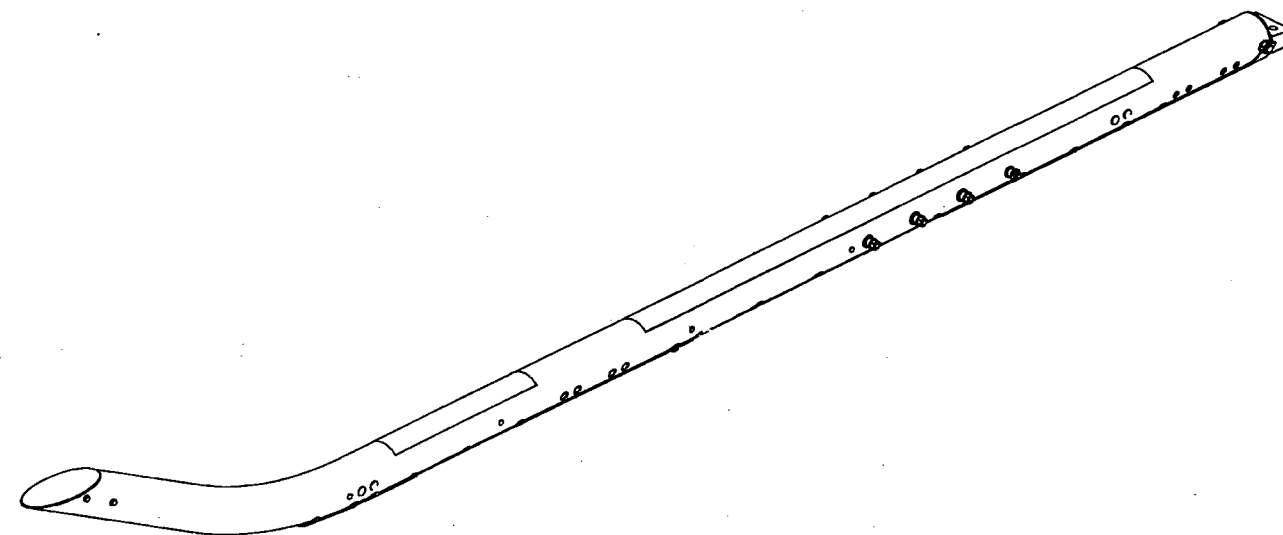
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

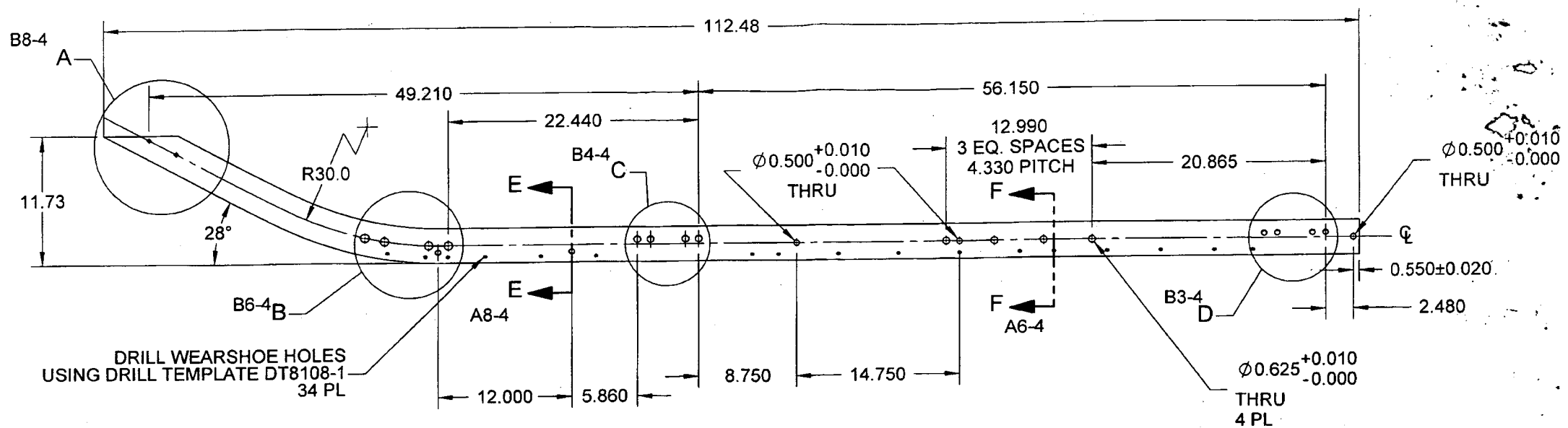
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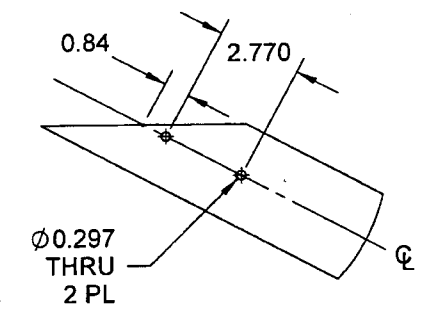


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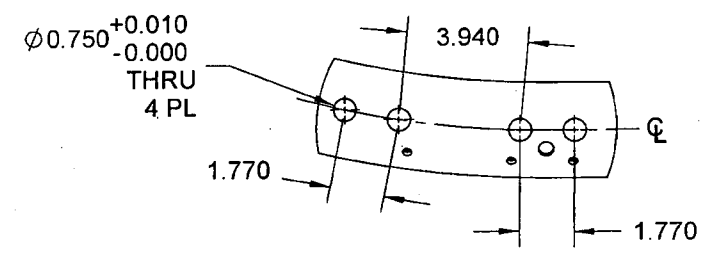


DRILL WEARSHOE HOLES  
USING DRILL TEMPLATE DT8108-1  
34 PL

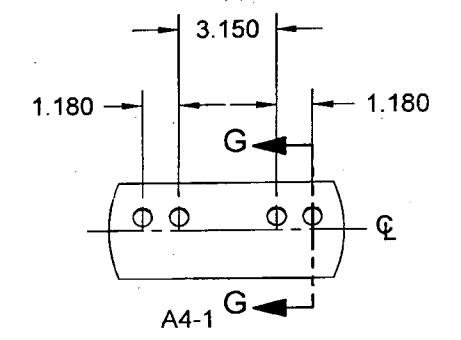
**D2750-1 LH SKIDTUBE**



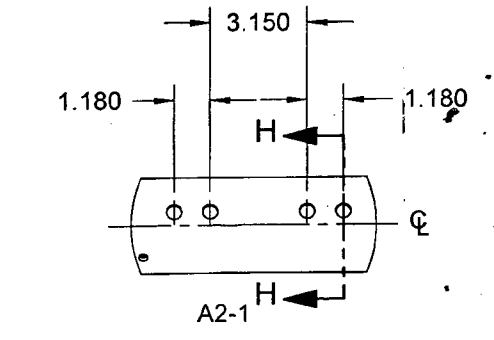
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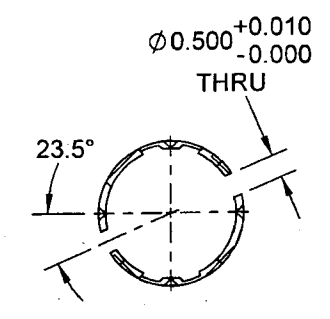
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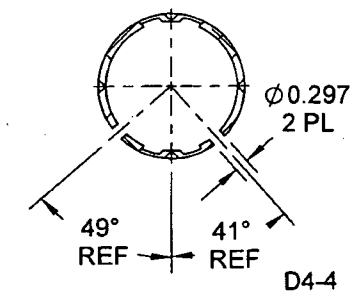
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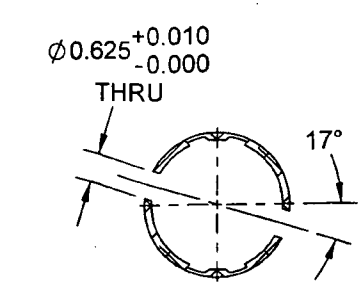
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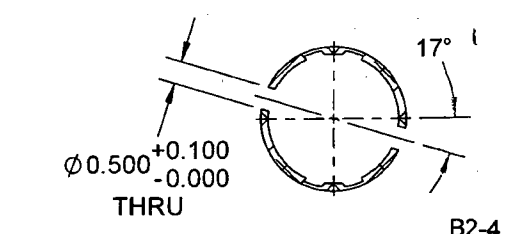
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



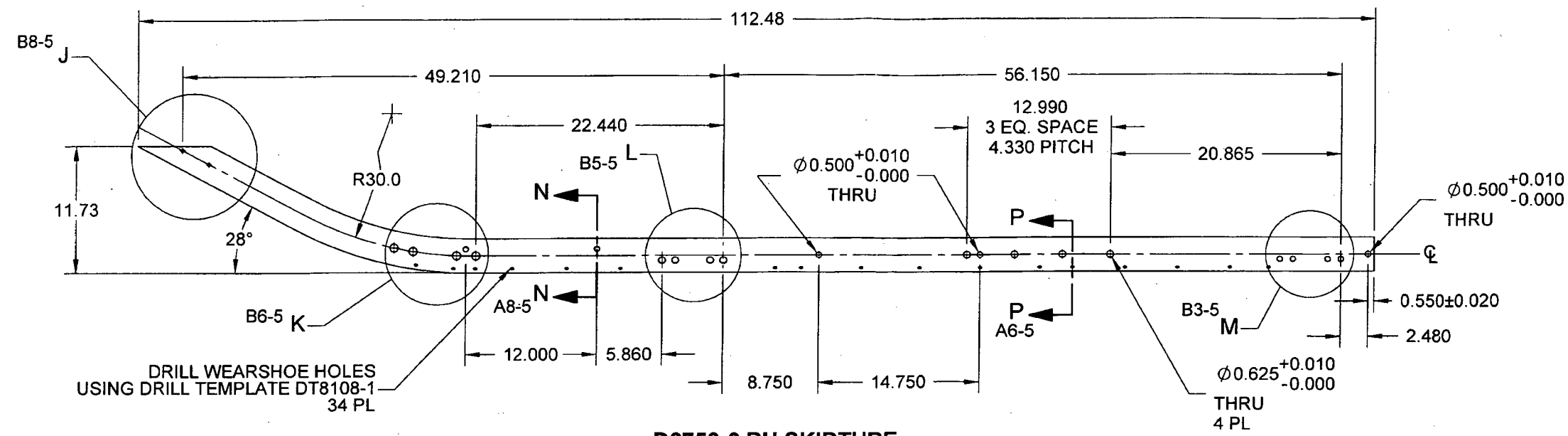
**SECTION H-H**  
SCALE 3X, 4 PL

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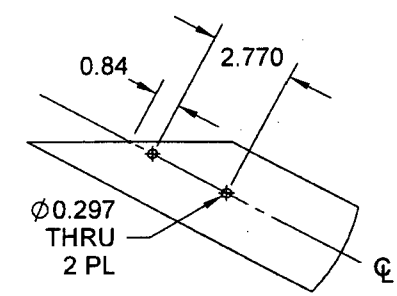
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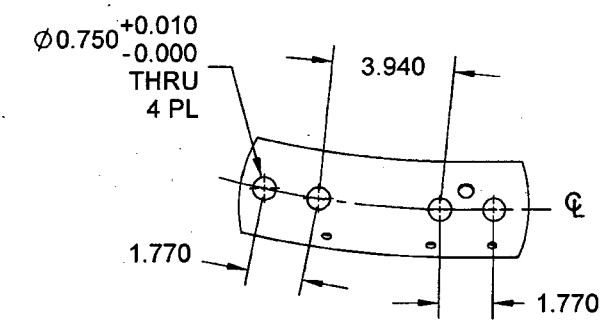
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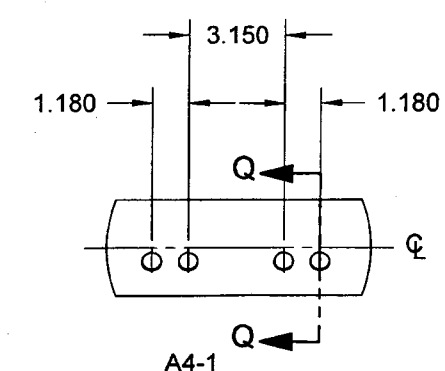
**D2750-2 RH SKIDTUBE**



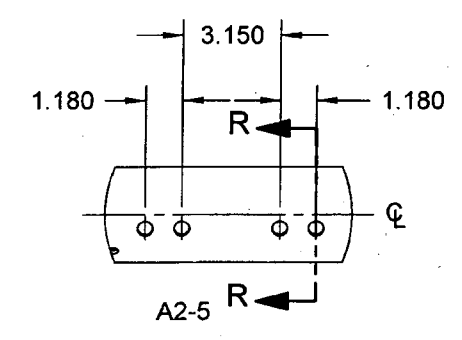
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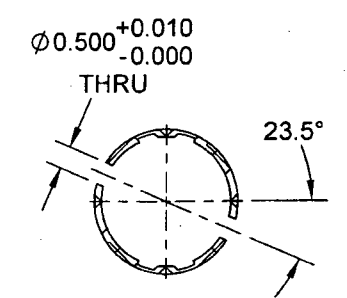
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C7-5  
SCALE 2X



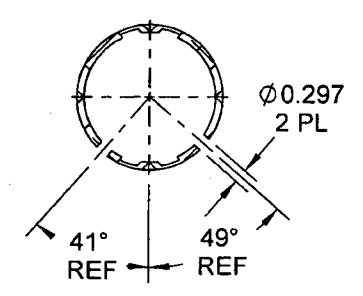
**DETAIL L**  
D6-5  
SCALE 2X



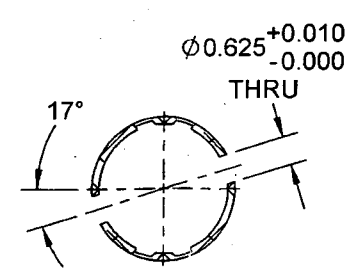
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SCALE 2X



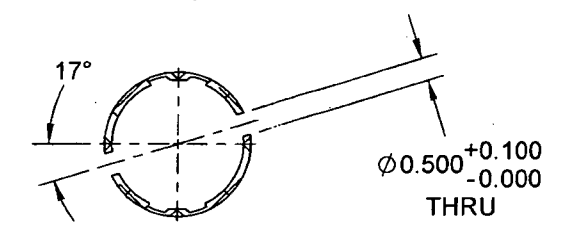
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SCALE 3X, 2 PL




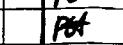
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C4-5  
SCALE 3X, 17 PL



**SECTION Q-Q**  
B5-5  
SCALE 3X, 4 PL



**SECTION R-R**  
B3-5  
SCALE 3X, 4 PL

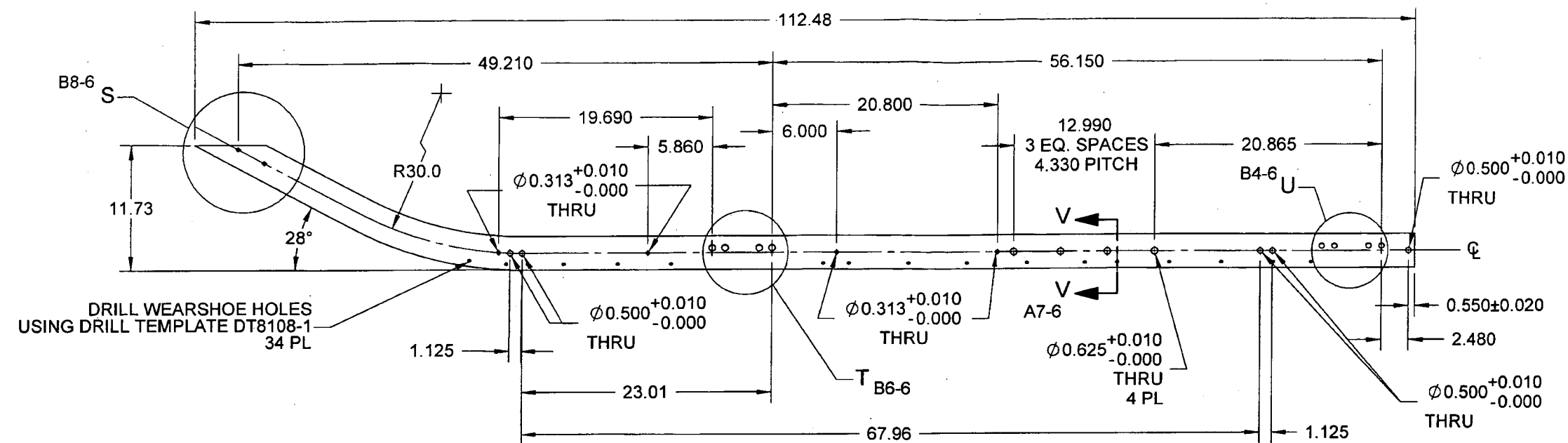
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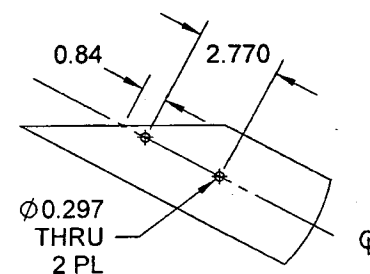
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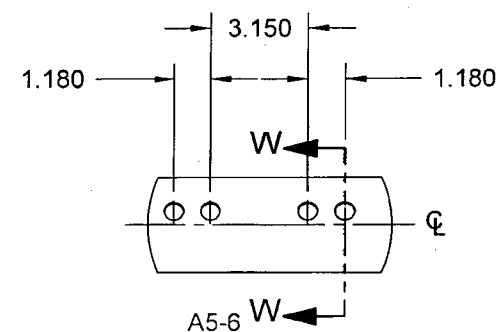
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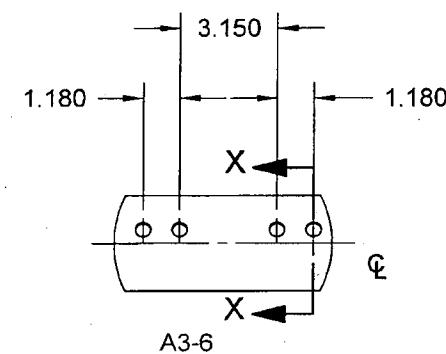
**D2750-3 LH SKIDTUBE**



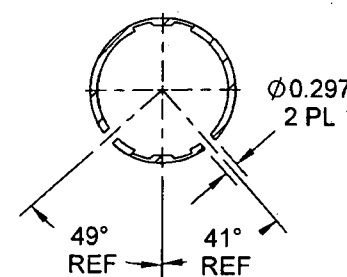
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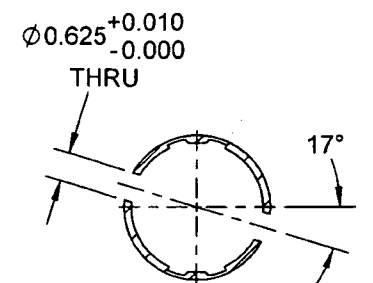
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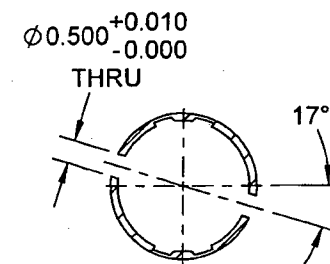
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

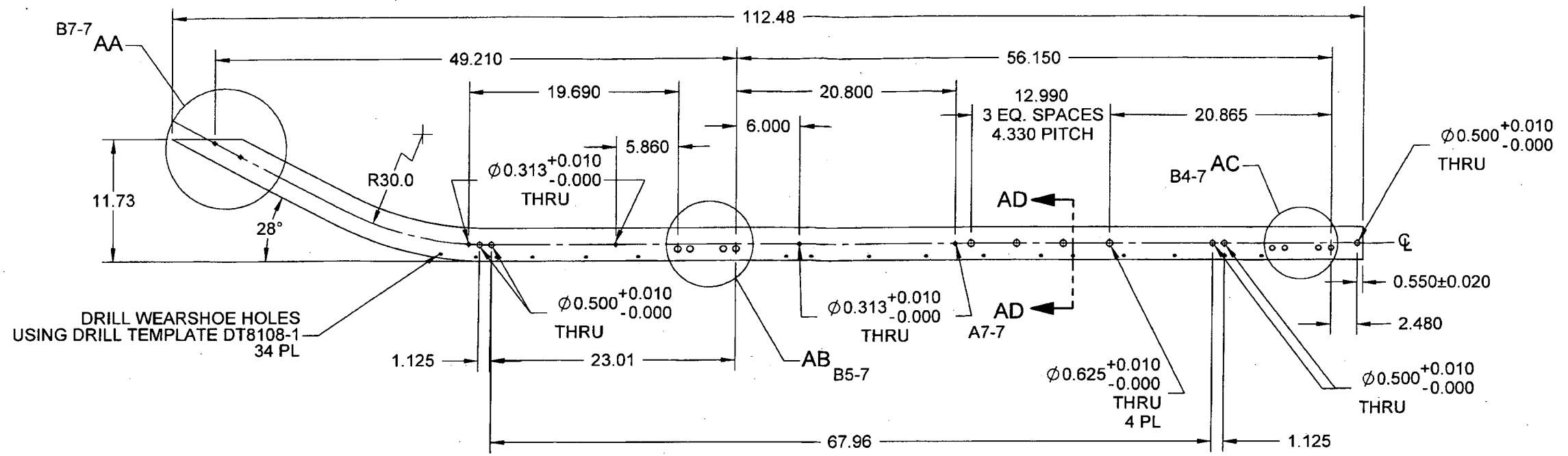
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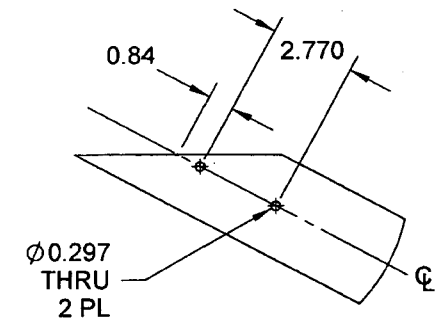
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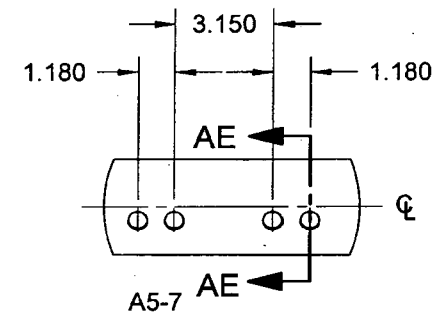
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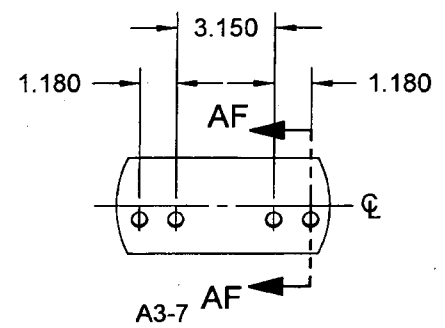
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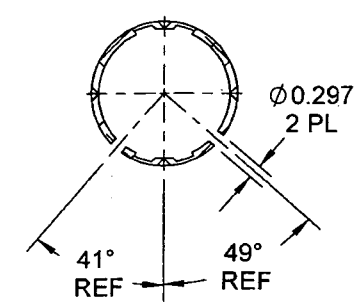
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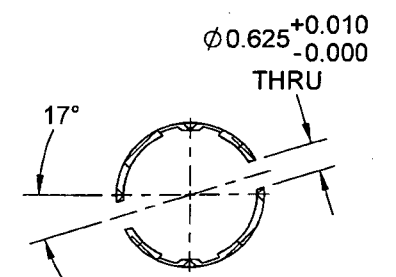
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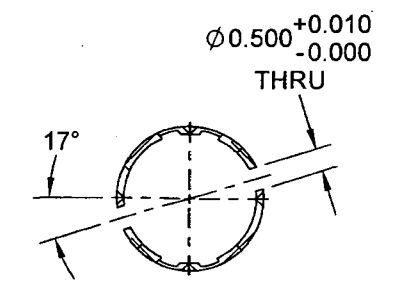
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



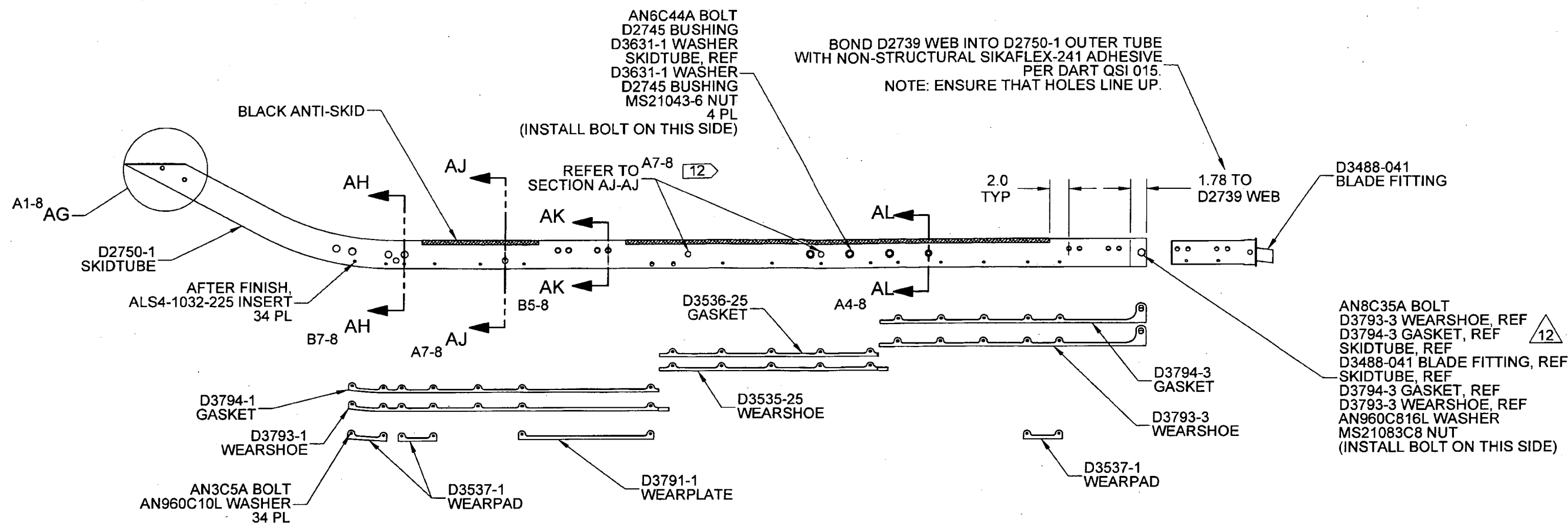
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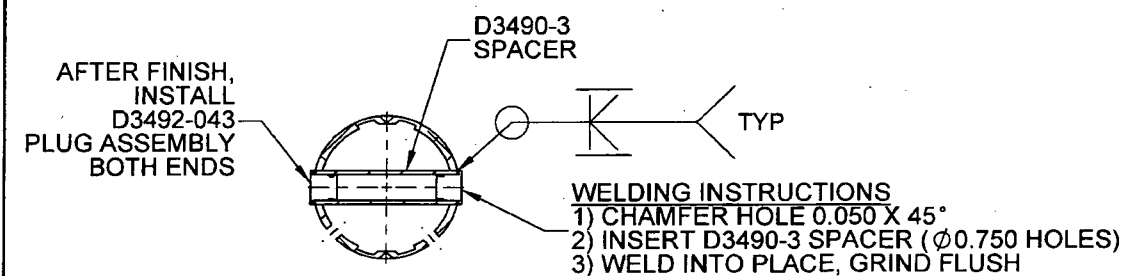
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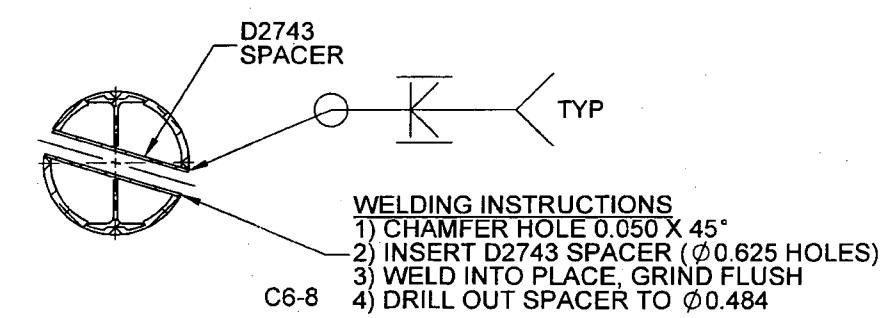
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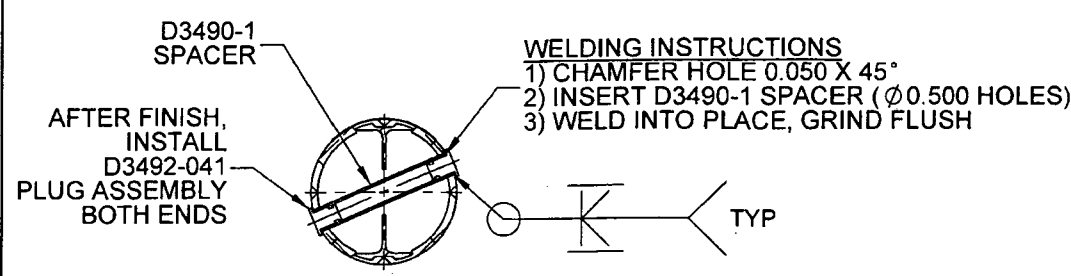
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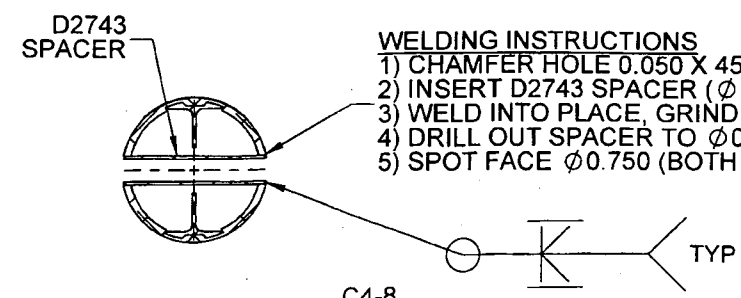
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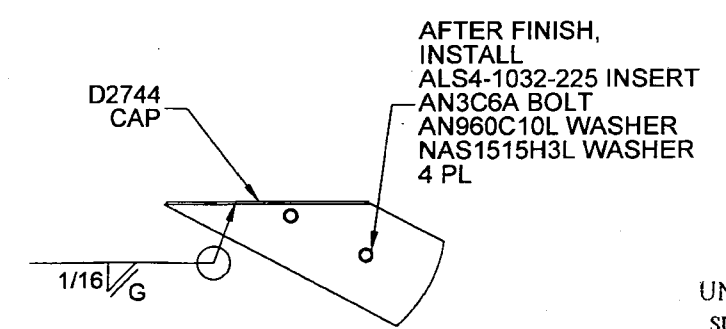
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AG**  
SCALE 2X

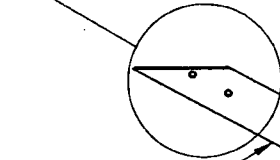
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DESIGN	<del>REV</del>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<del>REV</del>	PORT HADLOCK, WA	
CHECKED	<del>REV</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>REV</del>	D2750	SHEET 8 OF 11
APPROVED	<del>REV</del>	TITLE	SCALE
DE APPR.	<del>REV</del>	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

A1-9  
AM



D2750-2  
SKIDTUBE  
AFTER FINISH,  
ALS4-1032-225 INSERT  
34 PL

BLACK ANTI-SKID

REFER TO  
SECTION AP-AP

AN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL NUT ON THIS SIDE)

BOND D2739 WEB INTO D2750-2 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

2.0  
TYP

1.78 TO  
D2739 WEB

D3488-042  
BLADE FITTING

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
D3488-042 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)

AN3C5A BOLT  
AN960C10L WASHER  
34 PL

D3794-1  
GASKET

D3793-1  
WEARSHOE

D3537-1  
WEARPAD

D3791-1  
WEARPLATE

D3536-25  
GASKET

D3535-25  
WEARSHOE

D3537-1  
WEARPAD

D3794-3  
GASKET

D3793-3  
WEARSHOE

**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

AFTER FINISH,  
INSTALL  
D3492-043  
PLUG ASSEMBLY  
BOTH ENDS

D3490-3  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-3 SPACER (Ø 0.750 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

C7-9

**SECTION AN-AN**  
SCALE 3X, 4 PL

D2743  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484

C5-9

**SECTION AQ-AQ**  
SCALE 3X, 4 PL

D2744  
CAP

1/16" G

AFTER FINISH,  
INSTALL  
ALS4-1032-225 INSERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL

**DETAIL AM**  
SCALE 2X

AFTER FINISH,  
INSTALL  
D3492-041  
PLUG ASSEMBLY  
BOTH ENDS

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

C6-9, D5-9

**SECTION AP-AP**  
SCALE 3X, 4 PL

D2743  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø 0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø 0.484  
5) SPOT FACE Ø 0.750 (BOTH SIDES)

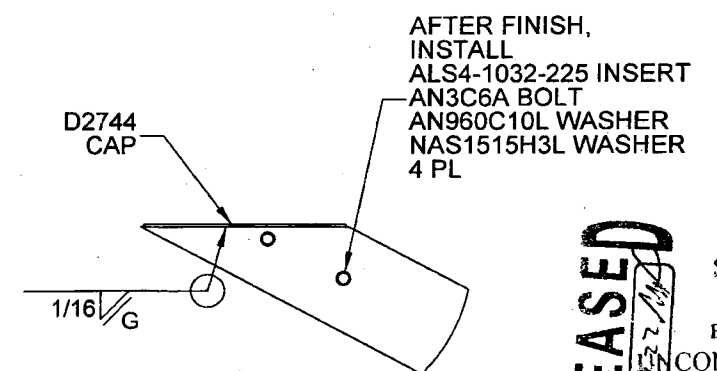
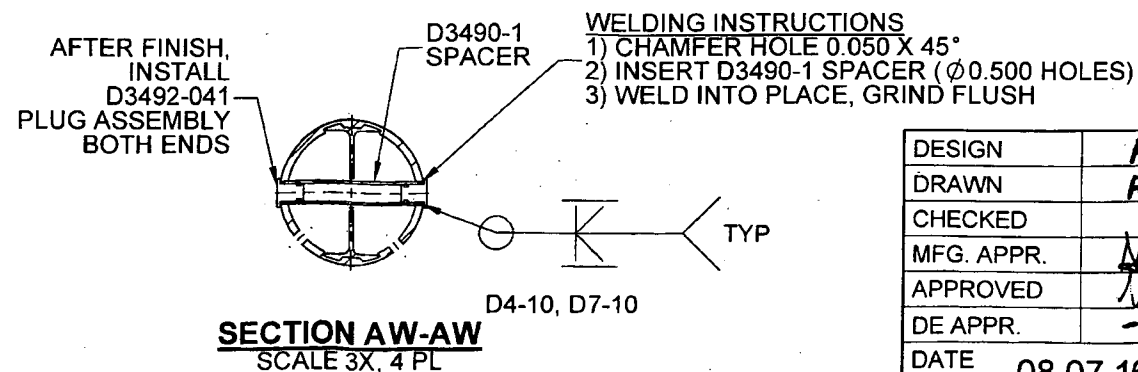
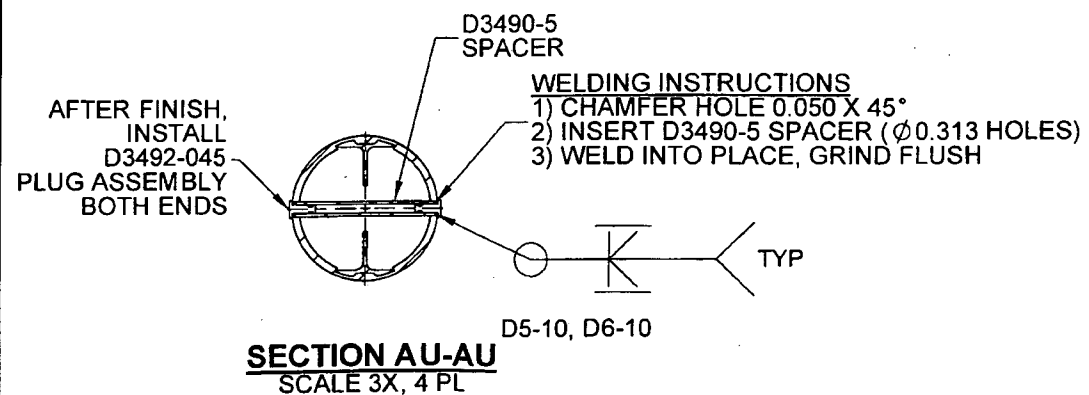
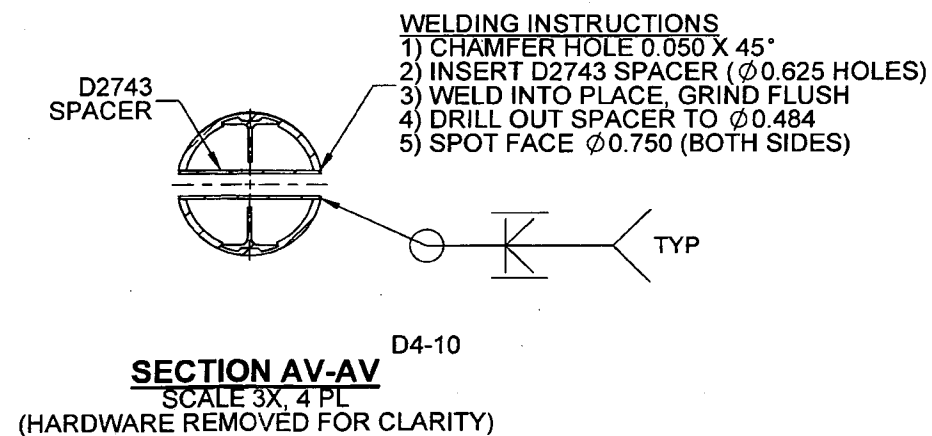
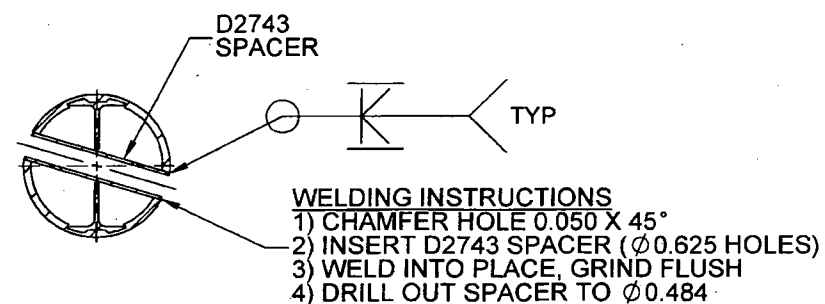
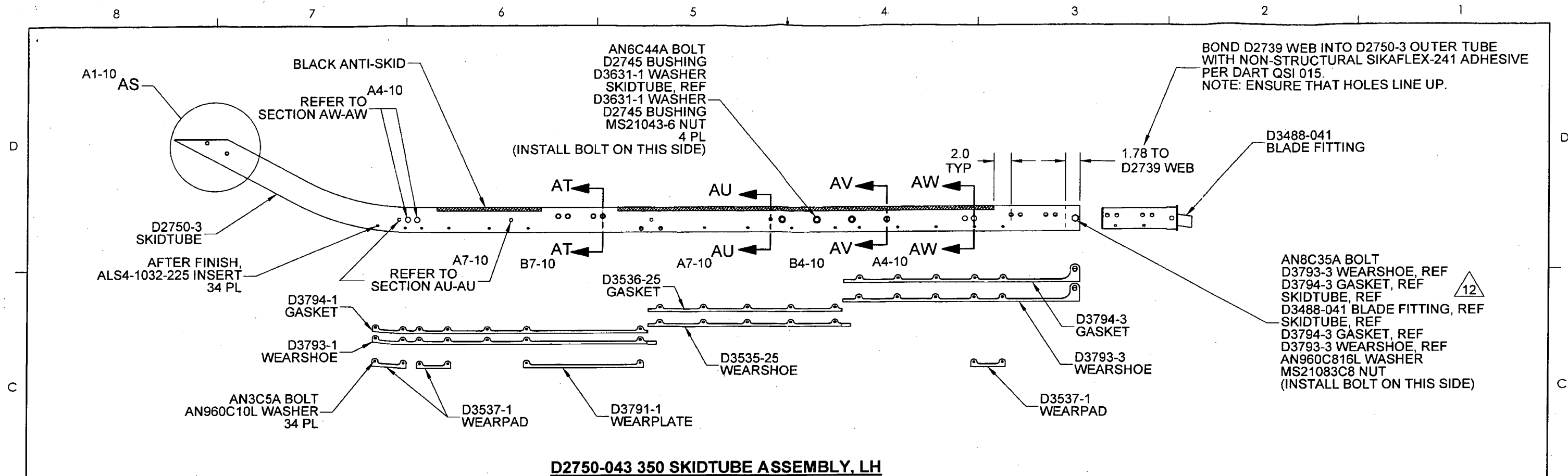
C4-9

**SECTION AR-AR**  
SCALE 3X, 4 PL  
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MFG. APPR.		D2750	SHEET 9 OF 11
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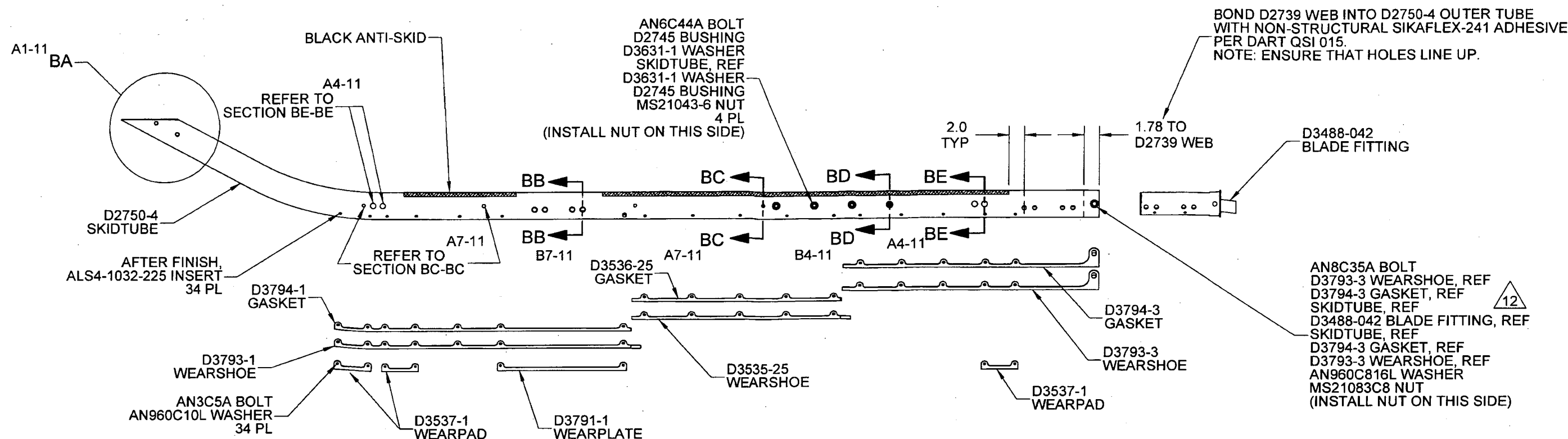
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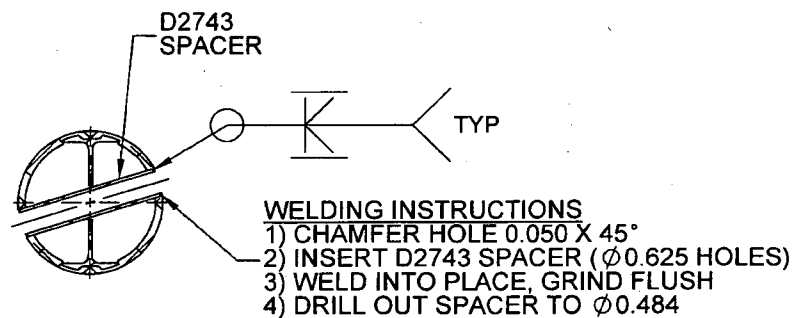
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MFG. APPR.	PA	<b>D2750</b>	SHEET 10 OF 11
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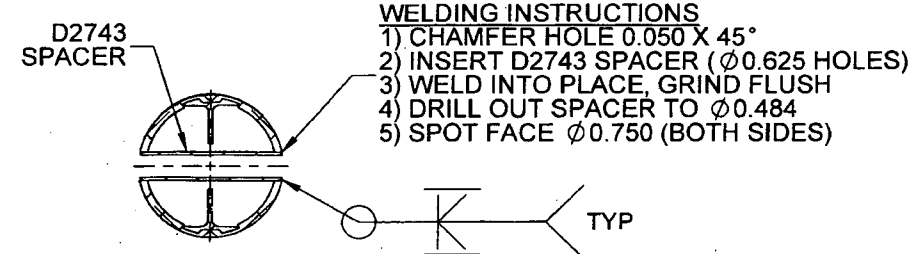
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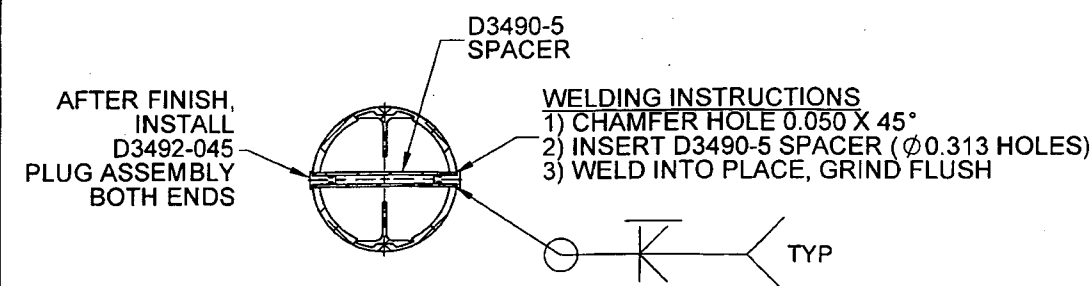
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



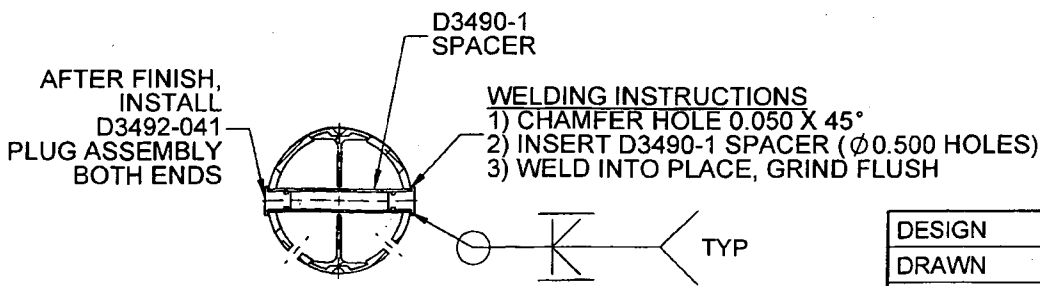
**SECTION BB-BB**  
SCALE 3X, 4 PL



**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

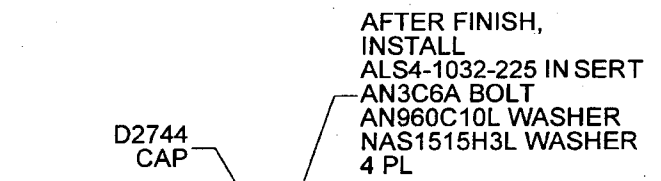


**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL

**RELEASED**  
08.07.16



**DETAIL BA**  
SCALE 2X

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